

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
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Contract #: 04-0120F4Cty: SF/Ala Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Siegenthaler, Peter**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-019613**Date Inspected:** 22-Jan-2011**Project Name:** SAS Superstructure**OSM Arrival Time:** 1900**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 700**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** See below**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** OBG Components**Summary of Items Observed:**

On this date Caltrans OSM Quality Assurance Inspector (QA Inspector) George Goulet was present during the times noted above for observations relative to the work being performed.

Bay 14

This QA Inspector randomly observed the following work in progress in Bay 14:

SMAW welding of weld joint SEG-3007AD-035 located on PCMK OBG segment 13AE. Welder was identified as 043661. QC was identified as ABF CWI Yu Jiao (QC1). Assisting QC1 at this location and appearing to be monitoring the welding operation and recording data was ZPMC QC Zhan Hai Feng (QCA1), who was not a CWI. Weld variables recorded by QCA1 appeared to comply with WPS-B-P-2212-TC-U4b-FCM-1 as verbally identified by QCA1.

FCAW welding of weld joint SEG-3007AB-015 located on PCMK OBG segment 13AE at panel point 118. Welder was identified as 066733. QC was identified as QC1. Assisting QC1 at this location and appearing to be monitoring the welding operation and recording data was QCA1, who was not a CWI. Weld variables recorded by QCA1 appeared to comply with WPS-B-T-2233-ESAB as verbally identified by QCA1.

FCAW welding of weld joint SEG-3007AU-092 located on PCMK OBG segment 13AE at panel point 118. Welder was identified as 037723. QC was identified as QC1. Assisting QC1 at this location and appearing to be monitoring the welding operation and recording data was QCA1, who was not a CWI. Weld variables recorded by QCA1 appeared to comply with WPS-B-T-2233-ESAB as verbally identified by QCA1.

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FCAW welding of weld joints SEG-3019S-041, 046 located on PCMK OBG segment 14E. Welder was identified as 066763. QC was identified as QC1. Assisting QC1 at this location and appearing to be monitoring the welding operation and recording data was QCA1, who was not a CWI. Weld variables recorded by QCA1 appeared to comply with WPS-B-T-2233-ESAB as verbally identified by QCA1.

SMAW repair welding of weld joint SEG-3019V-029 located on PCMK OBG segment 14E. Welder was identified as 066416. QC was identified as QC1. Assisting QC1 at this location and appearing to be monitoring the welding operation and recording data was QCA1, who was not a CWI. Weld variables recorded by QCA1 appeared to comply with WPS-345-SMAW-3G(3F)-FCM-repair-1 as verbally identified by QCA1.

SMAW repair welding of weld joints SEG-3019BB-059, 081, 191 located on PCMK OBG segment 14E. Welders were, respectively, identified as 217087, 216086, 215553. QC was identified as QC1. Assisting QC1 at this location and appearing to be monitoring the welding operation and recording data was QCA1, who was not a CWI. Weld variables recorded by QCA1 appeared to comply with WPS-345-SMAW-2G(2F)-FCM-repair-1 as verbally identified by QCA1 and displayed on ZPMC Welding Repair Report B-CWR2737 presented by QCA1. See photo below of the document as presented.

FCAW welding of weld joints SEG3019J-246, 247, 252, 253 located on PCMK OBG segment 14E. Welders were identified as 217805. QC was identified as QC1. Assisting QC1 at this location and appearing to be monitoring the welding operation and recording data was QCA1, who was not a CWI. Weld variables recorded by QCA1 appeared to comply with WPS-B-T-2132-ESAB as verbally identified by QCA1.

SMAW repair welding of weld joint SEG-3019L-1-085 located on PCMK OBG segment 14E. Welder was identified as 067656. QC was identified as QC1. Assisting QC1 at this location and appearing to be monitoring the welding operation and recording data was QCA1, who was not a CWI. Weld variables recorded by QCA1 appeared to comply with WPS-345-SMAW-3G(3F)-FCM-repair-1 as verbally identified by QCA1 and displayed on ZPMC Welding Repair Report B-CWR2645 presented by QCA1.

FCAW welding of weld joints DP3162-001-411, 412 located on PCMK OBG segment 14E. Welders were identified as 044824. QC was identified as QC1. Assisting QC1 at this location and appearing to be monitoring the welding operation and recording data was QCA1, who was not a CWI. Weld variables recorded by QCA1 appeared to comply with WPS-B-T-2233-ESAB as verbally identified by QCA1.

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.

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Bay 14		车间/Location		WORK SHOP14
ZPMC		关键焊缝返修报告		版本
Critical Welding Repair Report (CWR)		Rev. No.:		0
项目名称 Project Name:	美国海湾大桥 SFOBB	部件图号 Drawing No.:	报告编号 Report No.:	B-CWR2737
合同号 Contract No.:	04-0120F4	部件名称 Item Name:	NDT 报告编号 NDT Report No.:	B787-JT-18549
项目编号 Project No.:	ZP06-787	ME FLOOR BE	AM	
焊缝缺陷描述: Description of welding discontinuity:				
Vertical Shear R to BTM R SPCM 板UT探伤缺陷总长度超过最大允许总长度返修 over length defects repair on SPCM				
weld No.(焊缝编号):				
SEG3019BB-037, SEG3019BB-059, SEG3019BB-081, SEG3019BB-125, SEG3019BB-147, SEG3019BB-169				
Document presented to this QA				
Inspector by QCA1 for repair of weld				
joints SEG-3019BB-059, 081, 191				
04-0120F4 No. (编号): 070432, 037997, 037998, 067656, 066422, 048047, 0411605				
01 22 11 2055				

Summary of Conversations:

As noted above.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Eric Tsang, 150-0042-2372, who represents the Office of Structural Materials for your project.

Inspected By: Goulet, George

Quality Assurance Inspector

Reviewed By: Riley, Ken

QA Reviewer